

Date: Thursday, 08/03/2007 1:16:38 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG	
Job Number	: 31031A		Part Number	: D22491	
Estimate Number	: 10839		Drawing Number	: D2249 REV. E	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 08/03/2007		Drawing Revision	: E	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: 07/03/2007		Due Date	: 10/04/2007	
Previous Run	: N/A		Qty:	10	
Written By	: <u>Linda Lacelle</u>		Um:	Each	
Checked & Approved By	: <u>Linda Lacelle</u>				
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:		
1.0	M304S16GA	304/316 .063 Sheet		
		Comment: Qty.: 0.0903 sf(s)/Unit Total : 0.9030 sf(s) 304/316 .063 Sheet Batch: M101463	<u>M 07 03 14</u>	(10)
2.0	WATER JET	FLOW WATER JET		
		Comment: FLOW WATER JET 1-Cut as per Dwg D2249 Dwg Rev: E Prog Rev: E	<u>M 07 03 14</u>	(10)
		2-Deburr if necessary	<u>> M 07/03/14 -x 10</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>M 07 03 14</u>	(10)
4.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK	<u>J 07 03 14</u>	(10)
5.0	PACKAGING 1	PACKAGING RESOURCE #1		
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: N/A	<u>FC 07 03 22</u>	(10)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31031A

Part Number: D22491

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(16)

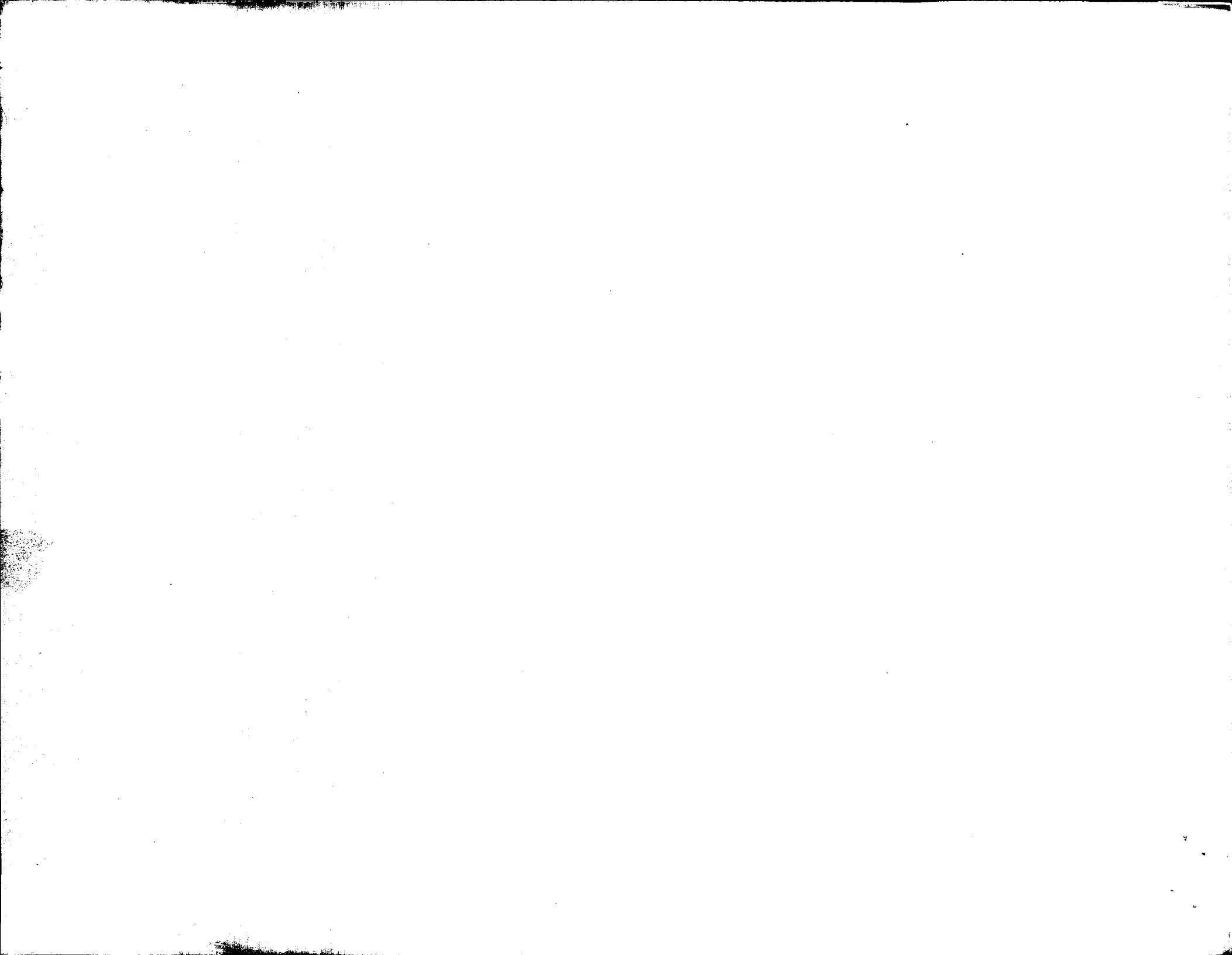
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1071031623

Job Completion



u of 03.23



Date: Wednesday, 3/7/2007 8:38:06 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG		
Job Number	: 31031A					
Estimate Number	: 10839					
P.O. Number	:		Part Number	: D22491		
This Issue	: 3/7/2007	S.O. No. :	Drawing Number	: D2249 REV. E		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type	Drawing Revision	: E		
Previous Run	:		Material	:		
Written By	:		Due Date	: 4/10/2007 Qty: 10 Um: Each		
Checked & Approved By	: <i>AD 07.03.07</i>					
Comment	: Est: D05.02.04 Added Step 9 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING Comment: PURCHASING Issue P/O: _____ Email or ship DXF file to vendor Laser Cut D2249-1 as per Dwg D2249 Material release note required <i>3045160 08681</i>
2.0	D22491F	Lug Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) <i>10011</i>
3.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <i>W 10011</i>
4.0	QC6	DIMENSIONAL CHECK Comment: DIMENSIONAL CHECK Inspect dimensions as per template D2249-1T1 & Dwg D2249 <i>10011</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr any rough edges <i>10011</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:38:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31031A

Part Number: D22491

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

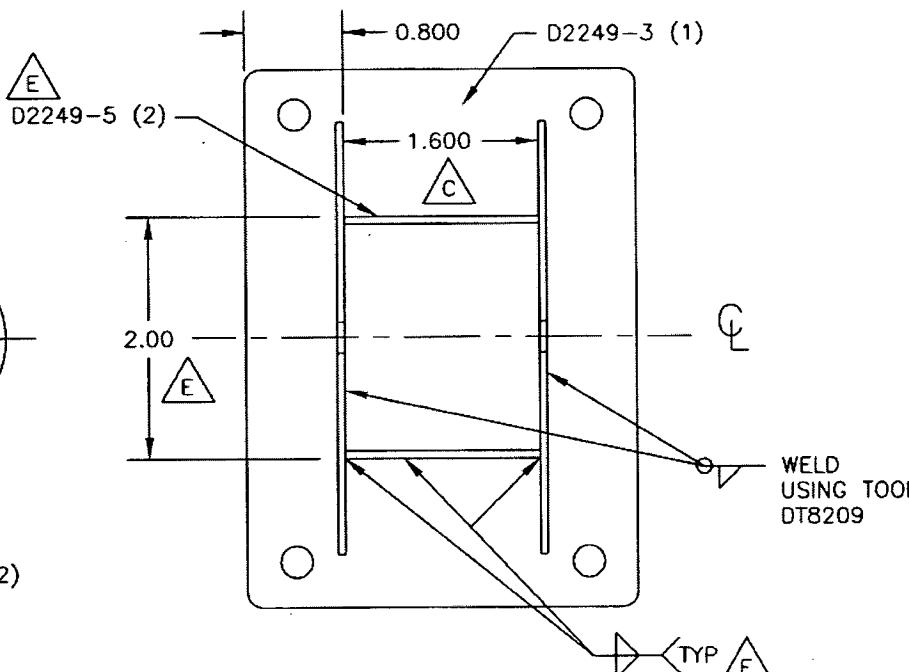
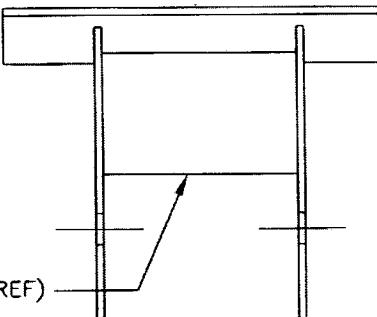
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**6-COPY
SERIAL****RELEASED****94.10.12
KE**

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED H	DRAWING NO. D2249	SHEET 1 OF 4
DATE 99.09.20	TITLE FITTING	SCALE NTS	
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14		
D	98.04.30	ϕ 0.261 WAS ϕ 0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	

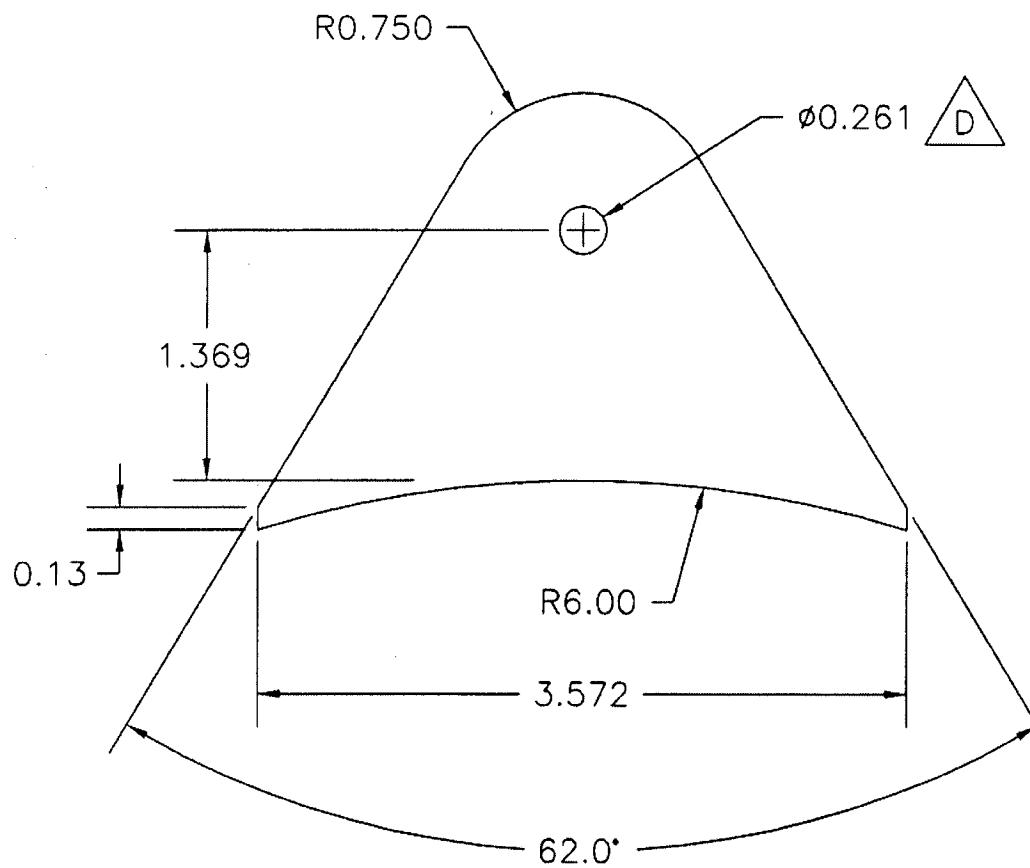
D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
 WELD PER DART QSI 004
 FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 ALL DIMENSIONS ARE IN INCHES
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

SHOP COPY
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 21031A

DARTCOPY ISSUED
09/09/2020

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED
99.10.12 KED2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. *31031A*

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>W</i>	DRAWING NO. D2249
DATE 99.09.20		REV. E SHEET 3 OF 4 SCALE 1:1

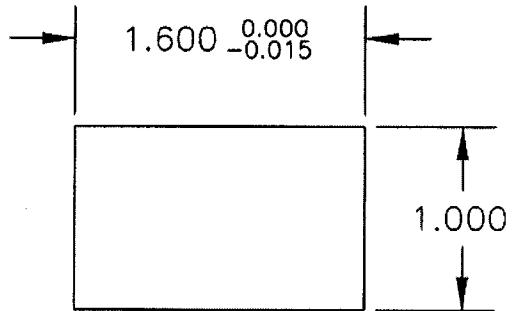
RELEASED
(99.10.12 KE)

</

DART

COPY ISSUED

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED
99.10.12 *KE*D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 31031A

DART AEROSPACE LTD	Work Order:	31031A
Description: Lvg	Part Number:	D2249-1
Inspection Dwg: D2249 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

✓ First Article □ Prototype

Measured by:	ml. off
Date:	07 03 14

Audited by:	<i>[Signature]</i>
Date:	07/03/14

Prototype Approval:	<i>N/A</i>
Date:	

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/JLM	